

Work Order ID 165530

Friday, August 25, 2017 11:51:30 AM

165530

Ship SEP 22

Page 1

Item ID: D206-581-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Handle, Fits LH or RH

Start Date: 8/25/2017 Start Qty: 30.00

30

Cust Item ID:

Required Date: 9/6/2017 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: **AUG 25 2017**

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D206-581

D

100

Document Control

DOCUMENT CONTROL

100

DC

Memo

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD206-581-015

CHG001

110

Pick Kit

110

Packaging

Memo

Packaging

120

QC4- 100% Inspect kits for completeness

120

QC

Memo

Quality Control

DAS
6
-89**AUG 28 2017**

0.00

0.00

0.00

0.00

0.90

30

DAS
27
9-89

SEP 08 2017

30

AUG 31 2017

nl

DAS
28
9-89

30

DAS
27
9-89

SEP 08 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 165530

Friday, August 25, 2017 11:51:30 AM

165530

Page 2

Item ID: D206-581-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Handle, Fits LH or RH

Start Date: 8/25/2017 Start Qty: 30.00

30

Cust Item ID:

Required Date: 9/6/2017 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-581-015
Location : FG018

30

DAS
27
9-89

SEP 11 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

3.00

Quality Control

DAS
21
9-89

SEP 11 2017

DAS
21
9-89

SEP 11 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

Friday, August 25, 2017 11:51:34 AM

Page 1

Work Order ID: 165530

165530

Parent Item: D206-581-015

D206-581-015

Parent Item Name: Step Handle, Fits LH or RH

Start Date: 8/25/2017

Required Date: 9/6/2017

Start Qty: 30.00

Required Qty: 30.00

Comments: Ipp Rev:A New Issue 10-07-16 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4103-1		Manufactured	No			110	Each	7.0000	1	30			
D4103-1									**			AUG 3 1 2017	
Step / Handle													

DAS
27
9-89

Location

Loc Qty

Loc Code

ST076

7

158054

7

80-005-3-8		Purchased	No			110	Each	25.0000	2	60			
80-005-3-8									**			AUG 3 1 2017	
INSERT													

DAS
27
9-89

Location

Loc Qty

Loc Code

ST585

25

M137075

25

MS27039-4-11		Purchased	No			110	Each	29.0000	2	60			
MS27039-4-11									**			AUG 3 1 2017	
Screw													

DAS
27
9-89

Location

Loc Qty

Loc Code

ST279

29

m133990

29

NAS1149D0416J		Purchased	No			110	Each	3,392.000	2	60			
NAS1149D0416.J									**			AUG 3 1 2017	
WASHER													

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

568

m131511

568

ST264

2824

m131511

2824

AUG 3 1 2017

60

DAS
28
9-89

DAS
6
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

Picklist Print

Friday, August 25, 2017 11:51:34 AM

Page 2

Work Order ID: 165530

165530

Parent Item: D206-581-015

D206-581-015

Parent Item Name: Step Handle, Fits LH or RH

Start Date: 8/25/2017

Required Date: 9/6/2017

Start Qty: 30.00

Required Qty: 30.00

NAS1149D0463J

Purchased

No

110

Each

3,175.000

2

60

NAS1149D0463.J

Washer

**DAS
27
9-89**

Location

Loc Qty

Loc Code

GA	552	
M135056	40	
M137699	512	
Return2017	16	
M136665	16	
ST263	2607	
M137988	600	
<u>M138084</u>	407	
<u>M138230</u>	1600	

**DAS
28
9-89**

AUG 31 2017

44/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
		SEP 10 2017		Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DART AEROSPACE LTD.

D206-581

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5.0 PART LIST

5.1 D407-581-111/-011 AND D206-581-113/-013/-014/-015/-017 KITS

Qty -111	Qty -113	Qty -011	Qty -013	Qty -014	Qty -015	Qty -017	Part Number	Description
X							D407-581-111	PRE-FLIGHT KIT (407)
	X						D206-581-113	PRE-FLIGHT KIT (206A/B/L/L1/L3/L4)
2		X					D407-581-011	PRE-FLIGHT STEP KIT, LH/RH (407)
	1		X				D206-581-013	PRE-FLIGHT STEP KIT, LH (206A/B/L/L1/L3/L4)
	1			X			D206-581-014	PRE-FLIGHT STEP KIT, RH (206A/B/L/L1/L3/L4)
4	4				X		D206-581-015	STEP HANDLE KIT
						X	D206-581-017	RETENTION STRAP KIT
						2	D3031-3	LOOP
		1	1	1			D4101-041	PRE-FLIGHT STEP ASSEMBLY
			1				D4102-1	SHIM (206 LH)
				1			D4102-2	SHIM (206 RH)
	1						D4102-3	SHIM (407)
					1		D4103-1	STEP HANDLE
						1	D4104-041	DOUBLER ASSEMBLY
						1	D4105-1	STRAP
						2	80-004-2D8	INSERT
					2		80-005-3-8	INSERT
	6	6	6				80-005-3-16	INSERT
						8	CR3243-4-1	RIVET
						2	MS21042L3	NUT
						2	MS24694-S47	SCREW
						2	MS24694-S50	SCREW
						2	MS24694-S52	SCREW
					2		MS27039-4-11	SCREW
	6	6	6				MS27039-4-14	SCREW
						2	NAS1149D0332J	WASHER (or AN960JD10L)
	6	6	6		2		NAS1149D0416J	WASHER (or AN960JD416L)
					2		NAS1149D0463J	WASHER (or AN960JD416)

Work Order ID 165530

Friday, August 25, 2017 11:51:30 AM

165530

Ship SEPT 22

Page 1

Item ID: D206-581-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Handle, Fits LH or RH

Start Date: 8/25/2017 Start Qty: 30.00

30

Cust Item ID:

Required Date: 9/6/2017 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: DATE Date: **AUG 25 2017**

Tooling:

Date:

Run

Start

NR1

QC: 21

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D206-581	D

6
39

100 Document Control
DOCUMENT CONTROL

AUG 28 2017

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD206-581-015

CHG001

SEP 08 2017

CB

110 Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

30 AUG 31 2017

nl

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.90

Quality Control



Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
K6A 1K7

Number: SH92-17

Issue No.: 7

Approval Date: June 19, 1992

Issue Date: October 26, 2001

Responsible Region:

Ontario

Aircraft/Engine Type or Model:

Bell 206 A, B, L, L-1, L-3, L-4, 407

Canadian Type Certificate or Equivalent:

H-92

Description of Type Design Change:

Utility Equipment Kit

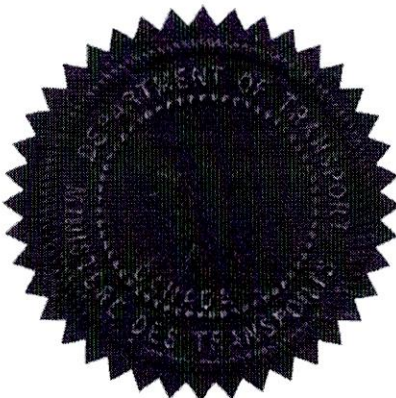
**Installation/Operating Data,
Required Equipment and Limitations:**

The Utility Equipment Installations, consisting of Cargo Mirror, Bear Paw and Preflight Sure-Grip Steps, are to be carried out in accordance with Dart Master Document List drawing no. D206-582, Rev. H, dated 01.10.01, or later Transport Canada approved revision.

Approved Combinations: These installations may be used in any combination provided the aircraft effectivity restrictions of the individual kits, as defined on the Dart Master Document List, are followed.

Required Equipment:

1. Flight Manual Supplement No. FMS-D206-582, Rev. C, dated 01.10.03, or later Transport Canada approved revision (for mirror installation)
2. Maintenance in accordance with the following ICA's (as required by combination installed):
ICA-D206-558, Rev. 0, dated 01.09.20 (Mirror),
ICA-D206-559, Rev. 0, dated 01.09.10 (Bear Paw),
ICA-D206-581, Rev. 0, dated 01.09.26 (Steps), or later Transport Canada accepted revisions.



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated will not adversely affect the airworthiness of the modified product.

Alex Pompei
Alex Pompei
For Minister of Transport

Canada